

Work Order ID 86134

86134

Page 1

June-21-12 8:37:01 AM

Item ID: D3783-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle Brace Assembly

Start Date: 21/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date: 12/06/21 SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3783	Rev A

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100

Packaging Memo 0.00

Packaging

2 0 FF
12-08-13

110	Small Fab	0.00							
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110

Small Fab Memo 0.00

Small Fab 1-assemble as per dwg D3783

2 0 FF
12-08-13

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC Memo 0.00

Quality Control

SMB
12-8-14
DAS
16
0-89
12/06/14

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86134***86134***

Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle Brace Assembly

Start Date: 21/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **254**

0.00

130

Packaging

Memo

0.00

Packaging

54 8 12/08/14

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/8/16 FJ**12-08-15**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:37:06 AM

Page 1

Work Order ID: 86134

86134

Parent Item: D3783-045

D3783-045

Parent Item Name: Angle Brace Assembly

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN5-13A		Purchased	No			110	Each	88.0000	2	4			
										**	(2)	FF 12-08-13	
AN5-13A													
Bolt													

Location	Loc Qty	Loc Code
GA	10	
116003	10	
ST338	78	
108167	8	
118983	4	
121181	50	
15928	16	

AN960JD516	NAS1149D0563J	Purchased	No			110	Each	16.0000	4	8			
										**	8	(2)	FF 12-08-13
AN960JD516													
Washer													

Location	Loc Qty	Loc Code
ST338	16	
2612	16	

D3765-1		Manufactured	No			110	Each	8.0000	2	4			
										**	(2)	FF 12-08-13	
D3765-1													
Clevis													

Location	Loc Qty	Loc Code
ST243	4	
83374	4	
ST250	4	
81698	4	

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-21-12 8:37:06 AM

Page 2

Work Order ID: 86134

86134

Parent Item: D3783-045

D3783-045

Parent Item Name: Angle Brace Assembly

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 2.00

Required Qty: 2.00

D3769-5

Manufactured No

110

Each

0.0000

1

2

D3769-5

Tube

B86574

**

2

(2)

FF 12-08-13

MS21042L5

Purchased No

110

Each

1,332.000

2

4

MS21042L5

Nut

**

(2)

FF 12-08-13

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

832

108827

4

116105

5

116548

43

117611

18

119109

746

17651

8

2937

8

7

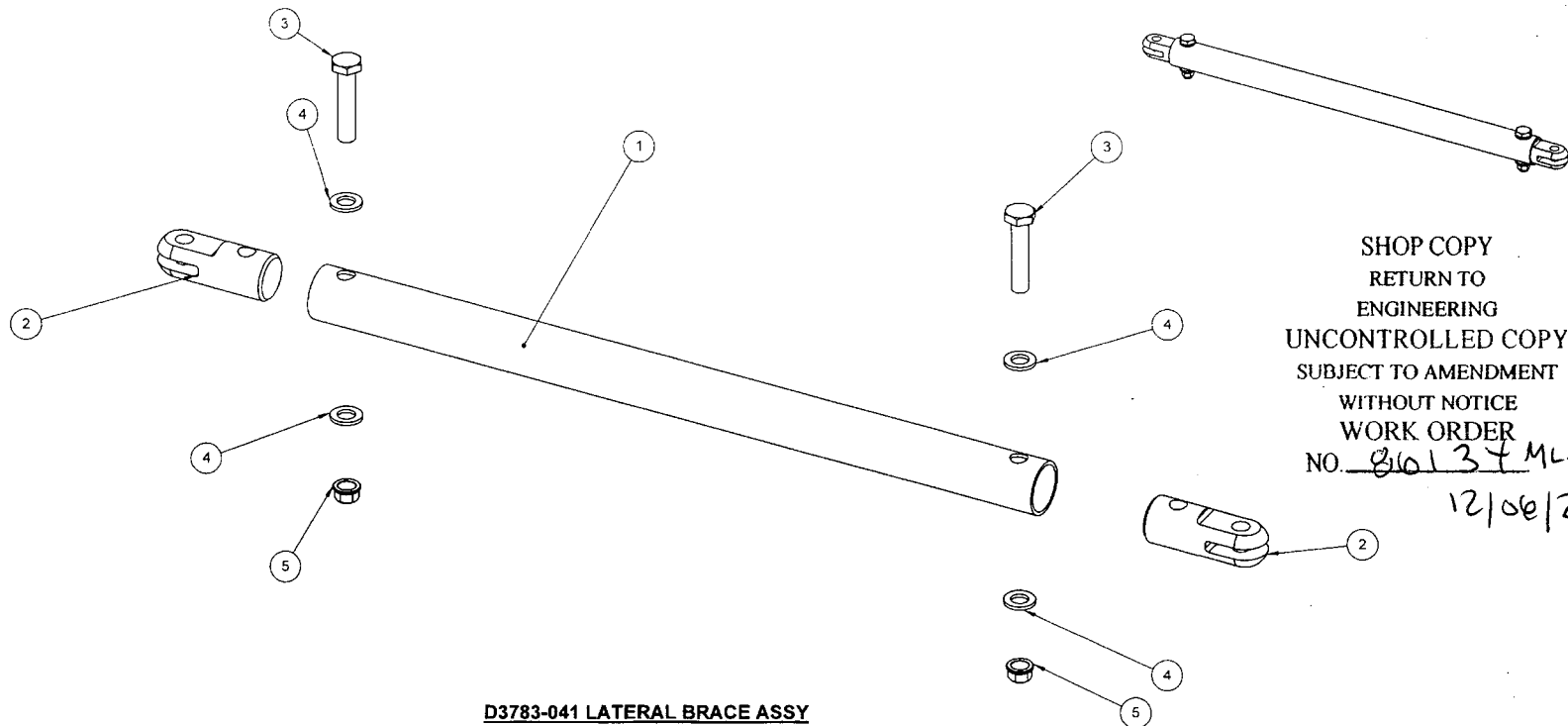
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 810134 MLJ
12/06/21

D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	ANS-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN980JD516)	4
5	MS21042L5	NUT	2

RELEASED
08.06.16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3783	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACE ASSEMBLY	NTS
DATE	08.06.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

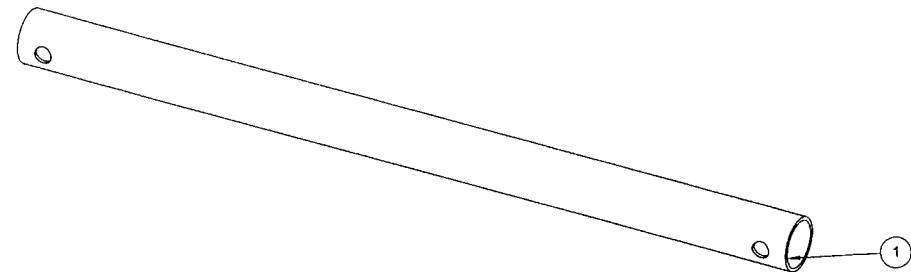
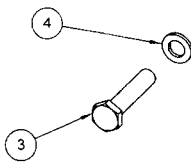
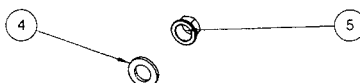
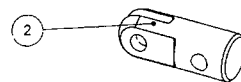
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



86134

D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

RELEASED
08-06-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3783
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 2 OF 3
DE APPR.	<i>[Signature]</i>	TITLE BRACE ASSEMBLY
DATE	08.06.04	SCALE NTS

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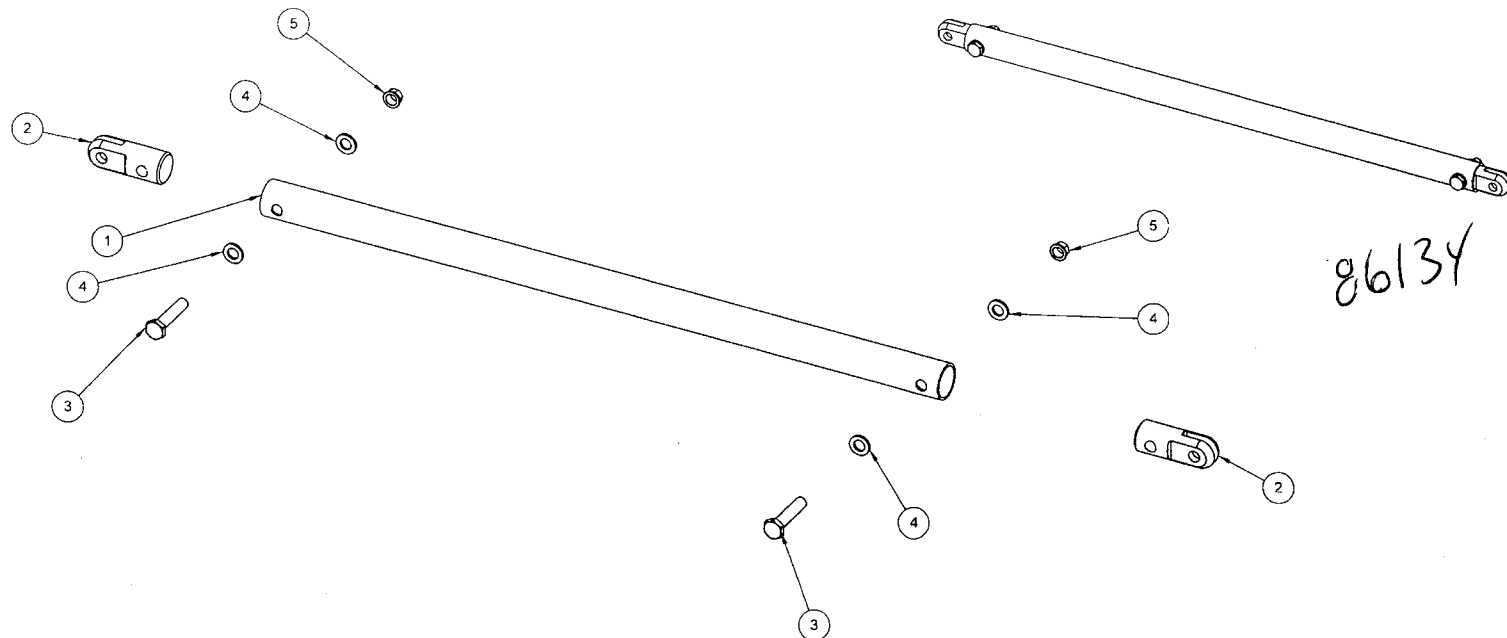
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
08-06-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3783	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACE ASSEMBLY	NTS
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